

Split

Date: Wednesday, 15/04/2009 2:57:32 PM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 47231 - /
Estimate Number : 13860
P.O. Number :
This Issue : 15/04/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : MACHINED PARTS
Previous Run : 47224
Written By :
Checked & Approved By : YMF 09-04-15
Comment : Est Rev:A New Issue 09-04-15 JLM Verified By:EC

Drawing Name : SEAT BELT GUIDE ASSEMBLY
Part Number : D39205
Drawing Number : D3920 PREL
Project Number : N/A
Drawing Revision : PREL
Material :
Due Date : 22/04/2009 Qty: 4 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01000 6061-T6 Bar .750 x 1.00



Comment: Qty.: 0.7875 f(s)/Unit Total : 3.1500 f(s)
6061-T6 Bar .750 x 1.00
BATCH: M104186

M.A 09/04/22

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blank 23.800" long

M.A 09/04/22

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA810 Rev: AA & Dwg D3920 Rev: PREL

2-Deburr per dwg D3920

09/04/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ASS 09.04.24

09.04.24

ENGINEERING
APPROVAL

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE ASSEMBLY

Job Number: 47231

Part Number: D39205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-04-24

(4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME:

10:50

OVEN TEMPERATURE:

330°

FINISH TIME:

11:20

BR 09-04-24

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

80264/24

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pag 4/24 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09104/24
MF
09-04-24

Job Completion



POSITIVE RECALL
EFFECTIVE DATE 09-04-24
RELEASED BS AUTH DATE 09-04-24

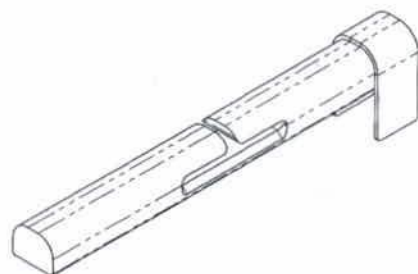
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

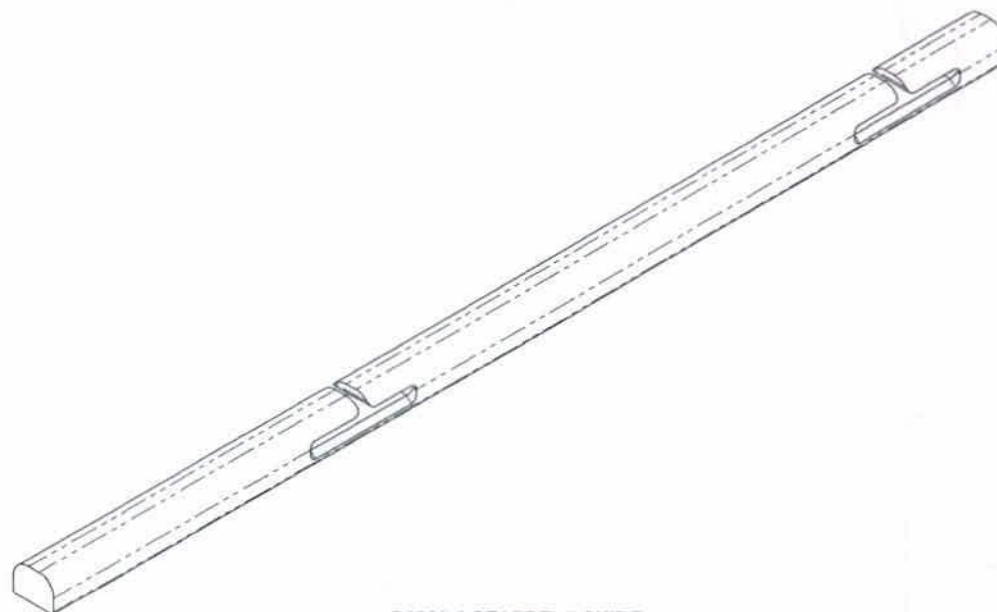
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3920-041 SEATBELT GUIDE ASSEMBLY



D3920-5 SEATBELT GUIDE

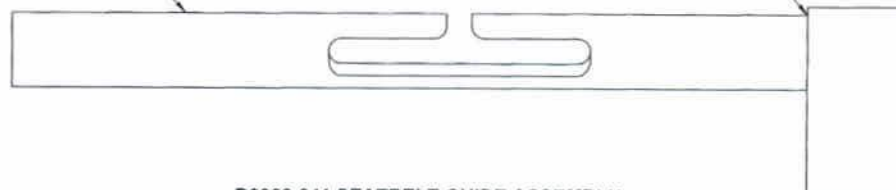
**PRELIMINARY
ISSUE**

AJS 09.04.14

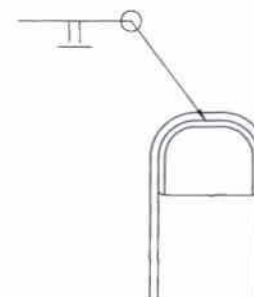
A		NEW ISSUE		DESCRIPTION		AJS	09.03.30
REV.						BY	DATE
DESIGN		AJS		DART AEROSPACE LTD			
DRAWN		AJS		HAWKESBURY, ONTARIO, CANADA			
CHECKED				DRAWING NO.		REV.	
MFG. APPR.				D3920		SHEET 1 OF 4	
APPROVED				TITLE		SCALE	
DE APPR.				SEATBELT GUIDE ASSY (214B/B1)		NTS	
DATE		09.03.30		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	BRACKET

D3920-1
SEAT BELT GUIDE



D3920-041 SEATBELT GUIDE ASSEMBLY



D3920-3
SEATBELT GUIDE BRACKET
(ASSEMBLE AT
CHAMFERED END)

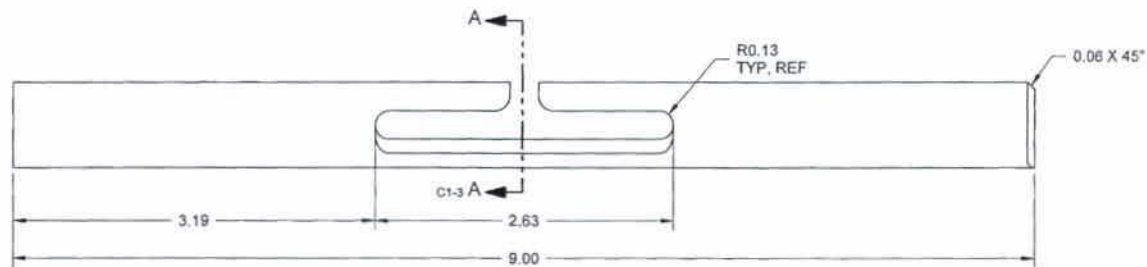
**PRELIMINARY
ISSUE**

ASS 09.04.14

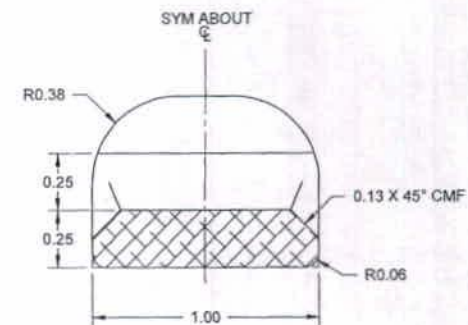
NOTES: D3920-041

- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

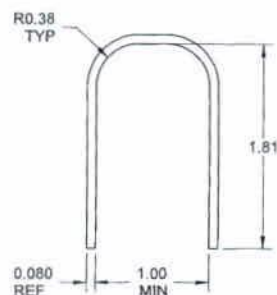
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



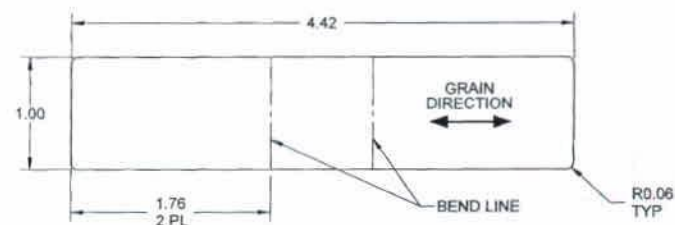
D3920-1 SEATBELT GUIDE



SECTION A-A
SCALE 2X



D3920-3 SEATBELT GUIDE BRACKET
(MAKE FROM D3920-3F)



D3920-3F FLAT PATTERN

NOTES: D3920-1A-3

1) MATERIAL -1: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B

-3: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11
REF DART SPEC M6061T6S.080

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

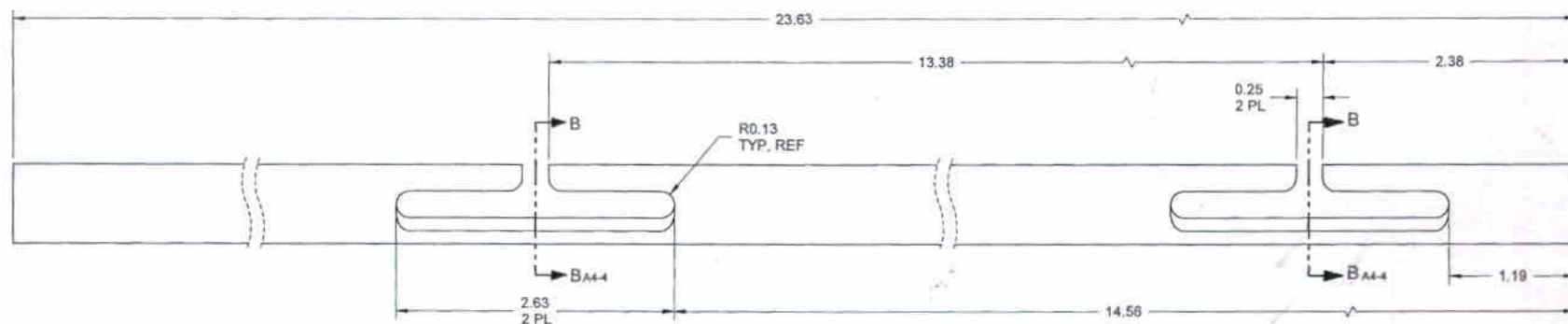
6) IDENTIFICATION: N/A

7) WEIGHT -1: 0.53 lbs

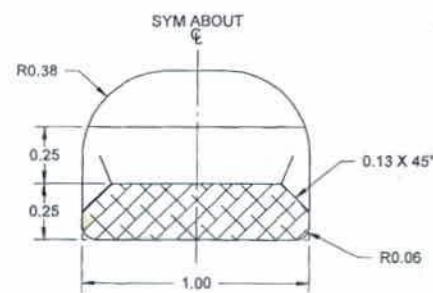
-3: 0.03 lbs

**PRELIMINARY
ISSUE**
AJS 09.04.14

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD	



D3920-5 SEATBELT GUIDE



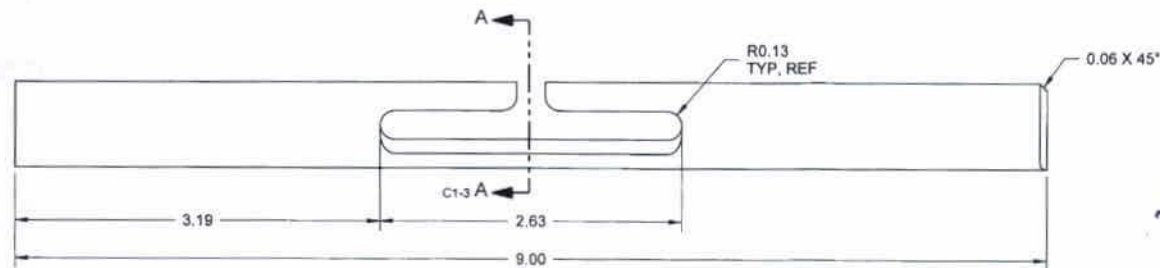
**PRELIMINARY
ISSUE**
ASS 09.04.14

NOTES: D3920-5

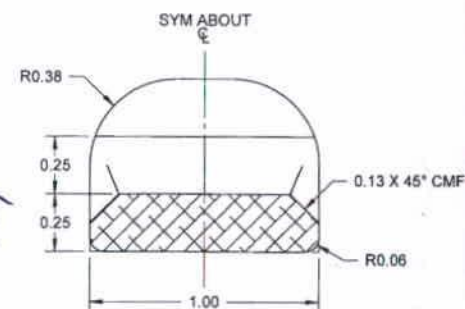
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.44 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

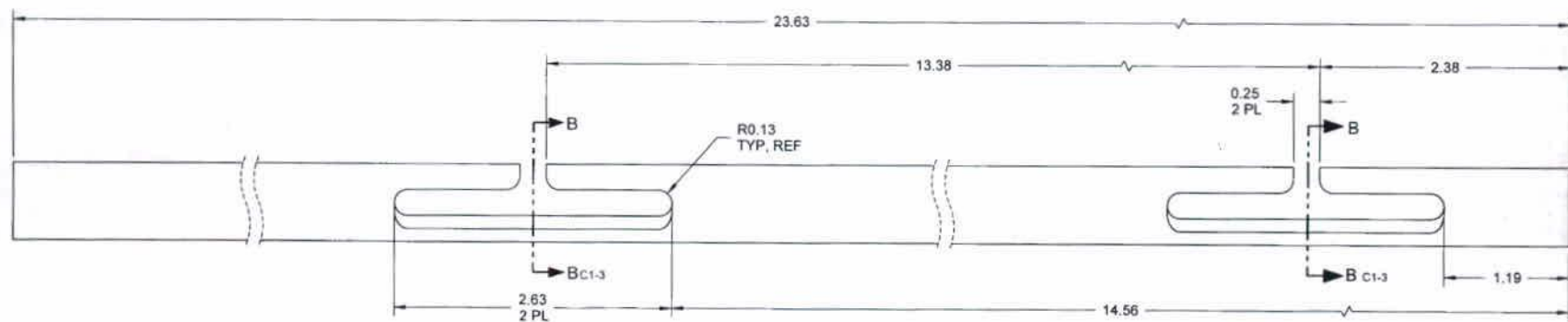


D3920-1 SEATBELT GUIDE



SECTION A-A C6-3
SCALE 2X
SECTION B-B B2-3
SCALE 2X B5-3

47231-1



D3920-5 SEATBELT GUIDE

NOTES: D3920-1&5

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.53 lbs
-5: 1.44 lbs

RELEASED
09/04/22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.04.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF A CONFIDENTIALITY AGREEMENT THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1